

Work Order ID 89634

89634

Page 1

Tuesday, August 28, 2012 10:12:45 AM

Item ID: D119-646-251

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Training Wearplates, Skidtube STD

Stop *NS2*

Start Date: 8/28/2012 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 8/29/2012 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: *mk*

Date: 12-08-28

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D119-646

B

100

0.00

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D119-646-251
CHG000

0.00

DAS
16
9-83

12/08/30

JB

MJS 12/08/30

2

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

2

12/08/29 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

DAS
16
9-83

12/08/30

(x2)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 89634

89634

Page 2

Tuesday, August 28, 2012 10:12:45 AM

Item ID: D119-646-251

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Training Wearplates, Skidtube STD

Stop *NS2*

Start Date: 8/28/2012 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 8/29/2012 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-646-251

Location:

PPP rev: *Draft*

12/8/30

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/08/30

MLJ 12/08/30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																								
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
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Picklist Print

Tuesday, August 28, 2012 10:12:44 AM

Page 1

Work Order ID: 89634

Parent Item: D119-646-251

Parent Item Name: Training Wearplates, Skidtube STD

Start Date: 8/28/2012

Required Date: 8/29/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<u>D3849-041</u> FWD WEARPLATE ASSY, STD/FLOAR GEAR		Manufactured	No			110	Each	3.0000	<u>1</u>	2		B89583	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		3							
				53030		1							
				75089		2							
<u>D3849-043</u> AFT WEARPLATE ASSY, STD GEAR		Manufactured	No			110	Each	1.0000	<u>1</u>	2		B89584	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		1							
				82669		1							
<u>D3904-1</u> Washer		Manufactured	No			110	Each	97.0000	<u>16</u>	32		20	50
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST068		97							
				51875		97							
<u>AN3C46A</u> BOLT		Purchased	No			110	Each	28.0000	<u>8</u>	16		20	12/08/29
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST354		20							
				122491		20							
				ST355		8							
				122204		8							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
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Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
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Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Picklist Print

Tuesday, August 28, 2012 10:12:44 AM

Page 2

Work Order ID: 89634

Parent Item: D119-646-251

Parent Item Name: Training Wearplates, Skidtube STD

Start Date: 8/28/2012

Required Date: 8/29/2012

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Nut

Purchased

No

110

Each

551.0000

8

16

JB 12/08/29

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

479

118077

2

118614

7

118686

30

119758

20

121255

20

121708

400

121708

Tuesday, August 28, 2012 10:12:44 AM

Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

4.0 PARTS LIST

4.1 Standard Skidtubes

Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
	X												D119-646-011	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, LH
		X											D119-646-012	STANDARD SKIDTUBE INSTALLATION WITH WEARPADS, RH
			X										D119-646-111	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, LH
				X									D119-646-112	STANDARD SKIDTUBE INSTALLATION WITH FULL LENGTH WEARPLATES & WEARPADS, RH
					X								D119-646-211	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, LH
						X							D119-646-212	STANDARD SKIDTUBE INSTALLATION WITH TRAINING WEARPLATES, RH
	1	1					X						D119-646-041	REPLACEMENT STANDARD SKIDTUBE WITH WEARPADS
			1	1				X					D119-646-141	REPLACEMENT STANDARD SKIDTUBE WITH FULL LENGTH WEARPLATES & WEARPADS
									X				D119-646-151	WEARPLATE KIT STANDARD SKIDTUBE
					1	1				X			D119-646-241	REPLACEMENT STANDARD SKIDTUBE WITH TRAINING WEARPLATES
											X		D119-646-251	TRAINING WEARPLATES STANDARD SKIDTUBE
	1	1	1	1	1	1						X	D119-646-311	GROUND HANDLING KIT
1							1						D3887-041	STANDARD SKIDTUBE ASSY. WITH WEARPAD
20								1					D3887-043	STANDARD SKIDTUBE ASSY. WITH WEARPLATE & WEARPAD
26									1				D3847-043	FWD WEARPLATE ASSY
27									1				D3847-045	CENTER WEARPLATE ASSY
28									1				D3847-047	AFT WEARPLATE ASSY
29									5				D3847-1	WEARPAD
30									1				D3847-11	WEARPAD
31									30				AN3C5A	BOLT
32									30				AN960C10L	WASHER (OR NAS1149C0332R)
40										1			D3887-045	STANDARD SKIDTUBE ASSY. TRAINING WEARPLATE
44											1		D3849-041	FWD TRAINING WEARPLATE ASSY
45											1		D3849-043	AFT TRAINING WEARPLATE ASSY
51											16		D3904-1	WASHER
52											8		AN3C46A	BOLT
53											8		MS21043-3	NUT
60	2		2		2								D3883-1	SADDLE, OUTSIDE, LH
61		2		2		2							D3883-2	SADDLE, OUTSIDE, RH
62	2		2		2								D3884-1	SADDLE, INSIDE, LH
63		2		2		2							D3884-2	SADDLE, INSIDE, RH
64	16	16	16	16	16	16							D2652	BUSHING
65	8	8	8	8	8	8							AN3C50A	BOLT
66	12	12	12	12	12	12							AN4C6A	BOLT
67	8	8	8	8	8	8							MS21250-05006	BOLT
68	8	8	8	8	8	8							AN960C10L	WASHER (OR NAS1149C0332R)

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Revision: B
Date: 09.06.29

DART AEROSPACE USA, INC.

REFERENCE ONLY

IIN-D119-646

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Item	Qty -011	Qty -012	Qty -111	Qty -112	Qty -211	Qty -212	Qty -041	Qty -141	Qty -151	Qty -241	Qty -251	Qty -311	Part Number	Description
69	24	24	24	24	24	24							AN960C416L	WASHER (OR NAS1149C0432R)
70	8	8	8	8	8	8							AN960C516L	WASHER (OR NAS1149C0532R)
71	8	8	8	8	8	8							MS21043-3	NUT
72	12	12	12	12	12	12							MS21043-4	NUT
73	12	12	12	12	12	12							D2712	SET SCREW
74	16	16	16	16	16	16							D3672-7	WASHER
75	24	24	24	24	24	24							D3672-3	WASHER
76	8	8	8	8	8	8							D3672-7	WASHER
80	1	1	1	1	1	1							D3407-041	TOW RING
81	1	1	1	1	1	1							D3417-5	WASHER
82	1	1	1	1	1	1							D3456-1	WASHER
83	1	1	1	1	1	1							MS21043-4	NUT
84	1	1	1	1	1	1							D3417-7	WASHER
90												2	D3886-041	LUG ASSEMBLY
91												8	D2652	BUSHING
92												4	AN3C46A	BOLT
93												4	AN960C10L	WASHER (OR NAS1149C0332R)
94												4	MS21043-3	NUT

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Revision: B
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